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What is claimed is:

1. An emulsifier for forming an oil in water emulsion comprising
 - a) a reaction product of maleic anhydride and a triglyceride oil from a plant or land animal
 - b) further reacted with water, Group IA and IIA metals, ammonium hydroxide, various amines, alkanolamines, polyols, alkoxylated alkanolamines, poly(alkylene oxide)s, or polyamines or mixtures thereof to form an emulsifier.
2. An emulsifier according to claim 1, wherein there is an average of 0.1 to 2 mole of succinate groups per mole of triglyceride oil.
3. An emulsifier according to claim 2, wherein said reaction product is reacted with an alkanolamine.
4. An emulsifier according to claim 2, wherein said reaction product is reacted with a polyamine.
5. An emulsifier according to claim 2, wherein said reaction product is reacted with ammonium hydroxide.
6. An emulsifier according to claim 2, wherein said reaction product is reacted with triethanolamine.
7. A metalworking fluid comprising;
 - a) a reaction product of maleic anhydride and a triglyceride oil from a plant or land animal, optionally further reacted with water, Group IA and IIA metals, ammonium hydroxide, various amines, alkanolamines, and polyamines to form an emulsifier,

- b) a major amount of water, and
- c) optionally an oil selected from the group consisting of triglyceride oils, hydrocarbon oils (aliphatic, aromatic, petroleum distillates, poly(alpha olefins), Fischer Tropsch oils, etc), and ester oils other than triglyceride oils.

8. A metalworking fluid according to claim 7, wherein said reaction product is present in an amount from about 0.5 to about 10 weight percent based on the weight of said fluid.

9. A metalworking fluid according to claim 8, wherein said reaction product has from about 0.1 to about 2 mole of succinate groups per mole of triglyceride oil.

10. A metalworking fluid according to claim 8, further comprising at least one of a corrosion inhibiting agent and/or a antiwear agent.

11. A metalworking fluid according to claim 10, further comprising an extreme pressure agent.

12. A metalworking fluid according to claim 10, further comprising a biocide.

13. A metalworking fluid according to claim 7, wherein said optional oil is present from about 1 to about 50 weight percent based on the weight of said metalworking fluid.

14. A metalworking fluid according to claim 8, wherein said reaction product of maleic anhydride and triglyceride oil forms a succinated triglyceride oil which is then is reacted with an alkanolamine to form some a) ester linkages between the succinic acid of said succinated triglyceride and the alcohol of the alkanolamine and b) some salts of the succinic acid of said succinated triglyceride and the nitrogen atom of the alkanolamine.

15. A metalworking fluid according to claim 14, wherein said alkanolamine comprises triethanolamine.

16. A metalworking fluid according to claim 14, wherein said alkanolamine comprises an ethoxylated triethanolamine.

17. A metalworking fluid according to claim 14, wherein said alkanolamine comprises an alkanolamine with two alcohol substituents and one alkyl substituent or two alkyl substituents and one alcohol substituent.

18. A metalworking fluid according to claim 7, wherein said reaction product of maleic anhydride and a triglyceride oil comprises both the reaction product of a first triglyceride oil and maleic anhydride and the reaction product of a second different triglyceride oil and maleic anhydride.

19. A metalworking fluid according to claim 7, wherein said component c) comprises a triglyceride oil of a plant or land animal that hasn't been reacted with maleic anhydride.

20. A metalworking fluid according to claim 7, where said reaction product of maleic anhydride and a triglyceride oil from a plant or land animal is further reacted with an ethoxylated or propoxylated alkanolamine forming a half-ester salt.